

M303 RB :750

Work Order ID 148368

148368

Page 1

Tuesday, June 28, 2016 10:08:36 AM

Item ID: D5405-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bushing

Start Date: 6/27/2016

Start Qty: 30.00

30

Cust Item ID:

Required Date: 6/27/2016

Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

DAS
21

Date:

JUL 05 2016

Tooling:

Date:

Run Start

NR1

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5405

A

100

0.01

100

Hardinge

Hardinge CNC LATHE SMALL

Memo

0.15

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FB 4A & DWG D5405FOLIO REV: 4ADWG REV: B

2-DEBURR AS REQUIRED

94 ϕ

DAS

49

9-89

16/07/16

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.05

Quality Control

94 ϕ

DAS

49

9-89

16/07/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 148368

Tuesday, June 28, 2016 10:08:36 AM

148368

Page 2

Item ID: D5405-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 6/27/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.10

Quality Control

94

Ø

DAS

44

9-89

6-07-17

130

Identify as per dwg & Stock Location

0.00

130

Packaging

Memo

0.05

Packaging

94

DAS

Ø

9-89

JUL 19 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.50

Quality Control

11/07/22

ML5

DAS

21

9-89

JUL 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, June 28, 2016 10:08:35 AM

Page 1

Work Order ID: 148368

148368

Parent Item: D5405-1

D5405-1

Parent Item Name: Bushing

Start Date: 6/27/2016

Required Date: 6/27/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A 16.03.28 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.750

Purchased

No

f

97.0749

~~1.894737~~

5.70

M303R0 750

303 Round Bar 0.750

Location

Loc Qty

Loc Code

MAT028

97.074921

m133699

1.264921

m134677

0.82

m134776

10.99

m135094

84

6.03

DAS
49
9-89

16/07/16

DQA: _____ Date: _____



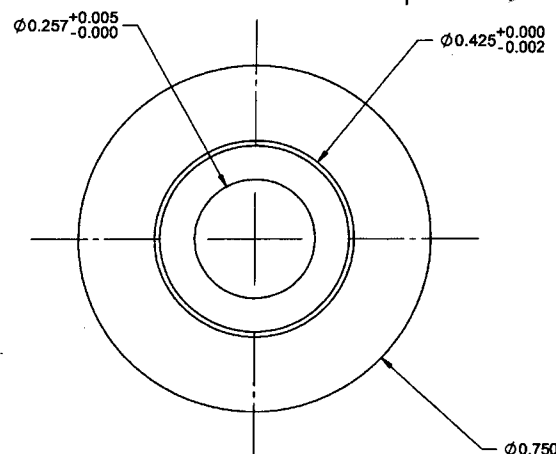
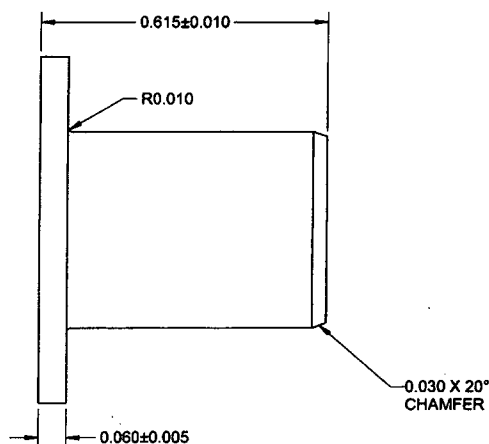
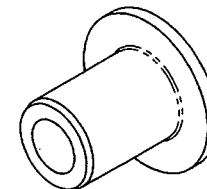
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178368 MJS
16-07-05



D5405-1 BUSHING

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR PER ASTM A583
OR AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M303R0.750 OR M304R0.750
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.021 lbs

RELEASED
2016-03-23
ECW 16-548

A NEW ISSUE		AK	16.02.19
REV.	DESCRIPTION		BY DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5405	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BUSHING	NTS
DATE	16.02.19	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CHANGED WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED